

x4 \_\_\_\_\_ 54  
12/05/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Dart Aerospace Ltd

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# Work Order ID 84031

**\*84031\***

Page 4

May-01-12 10:46:34 AM

Item ID: D3752-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Seat Frame

Stop **\*NS2\***

Start Date: 01/05/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Identify as per dwg & Stock Location S1 Z5Z A 0.00

**\*170\***

Packaging

Memo

0.00

Packaging

4/

565 12/5/11

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/5/15

mf  
12-05-15

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**NOTE:** Date & initial all entries



# Picklist Print

May-01-12 10:46:45 AM

Page 1

Work Order ID: 84031

\*84031\*

Parent Item: D3752-1

\*D3752-1\*

Parent Item Name: Seat Frame

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV: A New Issue 08.06.03 DL verified by:DD  
IPP Rev. B Dwg. Update 08/07/22 DL IPP Rev. C  
Dwg. Update Shorter length 08/10/28 DL IPP Rev D Add Step 105  
Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F60029-04		Purchased	No			100	sf	520.9974	10.667	42.668			
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\*MI FXS 125-F60029-04\*

GE PLASTICS LEXAN SHEET

\*\*

Location

Loc Qty

Loc Code

MAT019

520.9974

119937

520.9974

42.668

OK  
12/05/10

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	841031
<b>Description:</b> Seat Frame		<b>Part Number:</b>	D3752-1
<b>Inspection Dwg:</b> D3752	<b>Rev:</b> C	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

<b>Measured by:</b>	DL	<b>Date:</b>	12/05/10
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### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028	Min	0.048"	✓		Mx-3	
0.035	Min	0.059"	✓		Mx-3	
0.040	Min	0.079"	✓		Mx-3	
0.075	Min	0.108"	✓		Mx-3	
0.052	Min	0.088"	✓		Mx-3	
0.021	Min	0.035"	✓		DL-02	
0.036	Min	0.062"	✓		DL-02	

<b>Measured by:</b>	DL	<b>Date:</b>	12/05/11
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<b>Audited by:</b>	JB	<b>Date:</b>	12/05/11
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<b>Prototype Approval:</b>		<b>Date:</b>	
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Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL	fu

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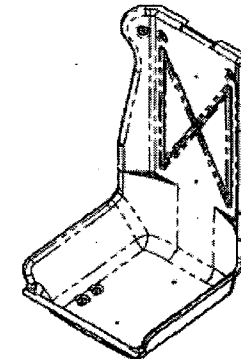
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84031

*MD-05-2*



RELEASED  
08/11/05

**D3752-1 SEAT FRAME**

ENSURE MATERIAL IN THIS AREA IS OPAQUE WITH A CONTINUOUS TEXTURE

OPTIONAL TOOLING HOLE  
0.028 MIN THICKNESS  
AT THIS LOCATION

OPTIONAL TOOLING HOLE  
0.035 MIN THICKNESS  
AT THIS LOCATION

0.040 MIN THICKNESS  
ALONG TOP EDGE

OPTIONAL TOOLING HOLE  
0.075 MIN THICKNESS  
AT THIS LOCATION

OPTIONAL TOOLING HOLE  
0.052 MIN THICKNESS  
AT THIS LOCATION

HEAVY HAIRCELL  
TEXTURE ON  
THIS SIDE

0.021 MIN THICKNESS  
IN THIS AREA (CORNER)

0.036 MIN THICKNESS  
ALONG BOTTOM EDGE

**NOTES:**

- 1) MATERIAL: F60029 LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, GY3778 COLOR (DARK GREY)  
(REF DART SPEC. MLEKS.125-F60029-04).
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3752-1" & B/N "BXXXXX" USING VIBRATING STYLUS
- 7) WEIGHT: 3.0 lbs
- 8) THERMOFORM PER DT8997 AND QSI 022. ORIENT TEXTURE AS SHOWN. TRIM TO MOLD.

C	REDUCE THICKNESS: 0.040 WAS 0.050 (2N C8-1), 0.075 WAS 0.100 (C8-1), 0.052 WAS 0.080 (B8-1), 0.021 WAS 0.030 (B8-1), 0.036 WAS 0.050 (A8-1), 0.028 WAS 0.035 (C8-1), 0.035 WAS 0.050 (D8-1). SOME HOLES NOW OPTIONAL (A8-1 TO D8-1).	CP	08.10.08
B	FRONT PORTION NOW SHORTER (B5-1), 18.0 WAS 19.6 (C4-1), 31.5 WAS 30.3 (B3-1). ADD 4 HOLES FOR THICKNESS MEASUREMENT (D8-1, B8-1).	CP	08.09.09
A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DD	DART AEROSPACE LTD	
DRAWN	DD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DD	DRAWING NO.	REV. C
MFG. APPR.	DD	D3752	SHEET 1 OF 1
APPROVED	DD	TITLE	SCALE
DE APPR.	DD	SEAT FRAME	NTS
DATE	08.10.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD	

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